

5/44

DART AEROSPACE LTD	Work Order:	24625
Description: Hinge Bracket	Part Number:	D2857-1
Drawing: D2857 Rev. A1	Qty:	24

RF 03.09.05

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	PD	05/10/21	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) Batch M188218	SP	05/11/0	24
3	HAAS	Machine per folio D2857-1	MS	05/11/3	24
4	QC	Inspect Level 2	MS	05/11/3	24
5	METAL	Tumble <u>N/A</u> / Deburr any rough edges after tumbling	MS	05/11/3	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	PU	05/11/10	24
7	QC	Inspect Level 7	ML	05/11/16	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	ML	05/11/16	24
9	QC	Inspect Level 3	CL	05/11/16	24
10	STORES	Identify and stock	LC	05/11/16	24
11	EXPEDITING	Close W/O Cost / Part: 23.09 5 ac 05/11/21 EY 22.30	PD	05/11/21	24

CL

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

EC JUN 26 2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 05/11/21

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD		Work Order:	24625
Description:	Hinge Bracket	Part Number:	D2857-1
Inspection Dwg:	D2857	Rev:	A1

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.307	—			
0.340	+/-0.010	.343	✓			
1.110	+/-0.005	1.108	✓			
1.790	+/-0.010	1.791	✓			
1.320	+/-0.005	1.322	✓			
2.000	+/-0.010	1.996	✓			
Ø0.171	+0.005/-0.000	.172	✓			
0.147	+/-0.010	.149	✓			
0.376	+/-0.010	.374	✓			
0.126	+/-0.010	.127	✓			
0.063	+/-0.010	.067	✓			
0.166	+0.005/-0.000	.167	✓			
0.911	+/-0.010	.915	✓			
0.600	+/-0.010	.603	✓			
0.125	+/-0.010	.126	✓			
0.150	+/-0.010	.145	✓			

Measured by:	RG	Audited by:	ML	Prototype Approval:	N/A
Date:	05.11.02	Date:	05/11/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	✓

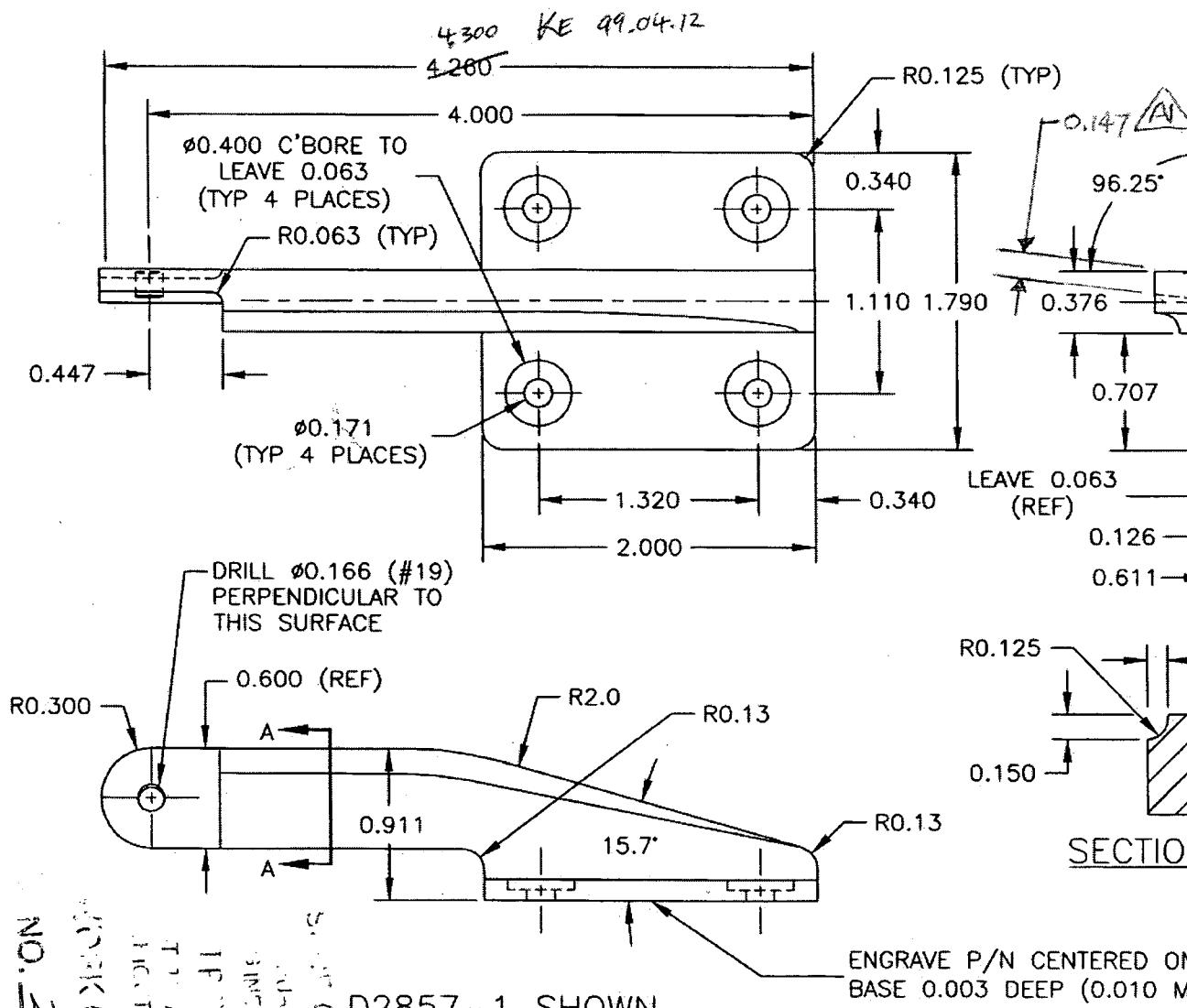
RELEASED

05/01/02-17



DRAWN BY		DART AEROSPACE LTD	
RE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
RE	RE	D2857	
DATE	TITLE	SHEET 1 OF 1	SCALE
98.12.14	HINGE BRACKET		1:1
A	98.12.14 NEW ISSUE		
A1	98.12.14 ADD THICKNESS		

KE 99.04.12



— ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2857-1 SHOWN
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 24625 ORDER

Job Costing Report

Dart Aerospace Ltd.
HawkesburyOct 20, 2005
04:09 pm

Work Order No : 0024625
 Project Name : D2857-1
 Project For : WK544
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2857-1
 Description : Hinge Bracket
 Manufactured : Yes
 Amount Req'd : 24
 Amount Done : 0
 Start Date : 10-20-05
 Est Finish Date : 11-03-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:41 pm

Work Order No : 0024625
 Project Name : D2857-1
 Project For : WK544
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2857-1
 Description : Hinge Bracket
 Manufactured : Yes
 Amount Req'd : 24
 Amount Done : 0
 Start Date : 10-20-05
 Est Finish Date : 11-03-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	19.50	100.00		
Production Cost :	0.00	466.37	100.00	0.00	466.37
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	14.00	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	466.37	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	466.37			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-466.37)

Date: Monday, 14/11/2005 8:10:45 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET		
Job Number	: 24625					
Estimate Number	: 10345					
P.O. Number	:			Part Number	: D28571	
This Issue	: 14/11/2005		S.O. No. :	Drawing Number	: D2857 REV A1	
Prsht Rev.	: NC			Project Number	:	
First Issue	: / /		Type :	Drawing Revision	: A1	
Previous Run	: 24501			Material	:	
Written By	:			Due Date	: 30/11/2005	
Checked & Approved By	:			Qty:	24	
Comment	: Est C 00.06.22 Removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B2000X01250	6061-T6 Bar 2.0" x 1.25"	
2.0	BAND SAW	BAND SAW	
	Comment: BAND SAW		
	Cut blanks 5.2"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
	Comment: HAAS CNC VERTICAL MACHINING #1		
	Machine per folio D2857-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1		
	1-Tumble		
	2-Deburr any rough edges after tumbling		
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
	Comment: HAND FINISHING RESOURCE #1		
	Acid etch and Alodine as per QSI 005 4.3		

Date: Monday, 14/11/2005 8:10:45 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 24625

Part Number: D28571

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

